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D3172-041
Job Sheet 187311



Part No: D3172-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/18

Job Tracking No:

Due Date: 1/11/19

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/11/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		1/11/19	0.00	25.00	Large Fab 8		
110	QC	1 pcs		1/11/19	0.00	0.00	QC9		
120	QC	1 pcs		1/11/19	0.00	0.00	QC5		
130	HandFinish	1 pcs		1/11/19	0.00	0.38	HandFinish2		
140	Powdercoat	1 pcs		1/11/19	0.00	1.04	Powdercoat1		
145	Packaging	1 pcs		1/11/19	0.00	0.00	Packaging3-1		
150	QC21-SA	1 Ea		1/11/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3
Descriptions: as per Dwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Dwg D3172 using Welding Table
6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per dwg 7- Weld D5365-1 as per dwg in
(2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8-
Weld mesh as per dwg 9- Use DT10465 jig to locate the bottom D3174-1 as per dwg

140 - 1ST COAT: START TIME: 1:30 OVEN TEMPERATURE: 345° FINISH TIME: 1:45.
***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: 1:38:51

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-3 ✓	Basket Hinge	2 Ea (2 ea) ✓	90-Start up Operation	5101748
D2327-3 ✓	Spacer Bushing	2 Ea (2 ea) ✓	90-Start up Operation	5079418
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	5125289
D3166-1 ✓	Basket Hoop	4 Ea (4 ea) ✓	90-Start up Operation	5083679
D3174-1 ✓	Mounting Lug	8 Ea (8 ea) ✓	90-Start up Operation	5071079
D5365-1 ✓	Lug	4 Ea (4 ea) ✓	90-Start up Operation	5080536
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5109214
M304TS0.750W.065 ✓	304 Sq Tube .75X.75X.065W	51 ft (51 ea) ✓	90-Start up Operation	5071985

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2232-3	2	21	0
	D2327-3	2	38	0
	D2581	2	52	0
	D3166-1	4	17	0
	D3174-1	8	59	0
	D5365-1	4	12	0
	M304EX0.75-16F	32	2,188	0
	M304TS0.750W.065	51	987	0
Part Specifications				
Specifications could not be found.				

Plex 11/30/18 9:19 AM dart.white.jesse

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____			MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor	
					QC / QA Coordinator	

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Container No: S143155



Part: D3172 - 041

Job No: 187311

Serial No/Batch: S143155

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/03/19

FAULT CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Tolerance
☐	Grain Direction	☐	Drawing
☐	Weld	☐	Finish
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Misread
☐	Off-set/Set-up		